

Work Order ID 153797

Friday, November 25, 2016 7:43:15 AM

153797

Page 1

Item ID: D4880-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut
Start Date: 12/2/2016 Start Qty: 200 ***2*** Cust Item ID:
Required Date: 12/8/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: NOV 29 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4880	C

100 DOOSAN LATHE 0.00

100

Doosan

Doosan Lathe

Memo

1- Turn as per Folio FB245

Rev: BA & Dwg D4880 Rev: C

2- Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																			
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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/2/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 12/8/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120 QC8- Inspect parts - second check

120

QC

Memo

0.00

0.01

Quality Control

130

130

Outsource2

Outsource process - NDT

Outsource process - NDT per QSI038 4.1

0.00

Memo

ISSUE P/O :

0.00

C OF C IS REQUIRED

140

140

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.01

7 0 44
9-89 16-12-08

7 DEC 13 2016

7x 80/6-12-13.

DQA: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 3-89
150						7			DEC 13 2016
QC	Memo	0.01							
Quality Control									
160	Identify as per dwg & Stock Location: B3	0.00							DEC 13 2016 DAS 26 9-89
160						7x			
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
170									DEC 13 2016
QC	Memo	0.03							
Quality Control									

16-12-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Work Order ID: 153797

153797

Parent Item: D4880-1

D4880-1

Parent Item Name: Strut

Start Date: 12/2/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased			No		f	14.9830		1.6			

M174PH-H900R0 750

17-4 SS H900 ROUND BAR 0.750"

Location

Loc Qty

Loc Code

MAT031

14.983

M129892

2.983

M136221

12

5.67 16-12-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

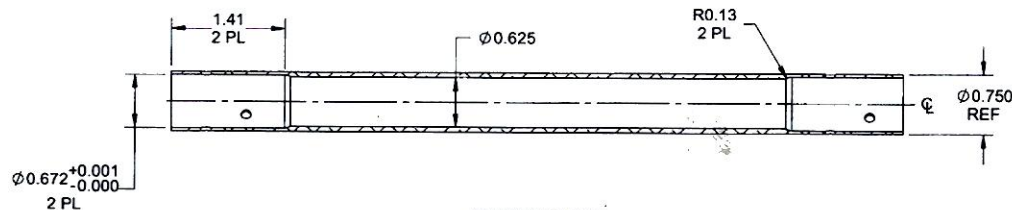
QA Closed: _____ Date: _____

Work Order update only ☐

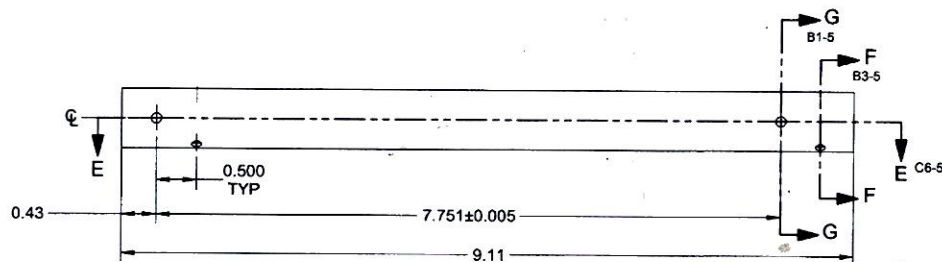
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																	
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SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153797 MCT
16-11-29



SECTION E-E B4-5



SECTION F-F C5-5
2 PL

SECTION G-G C5-5
2 PL

D4880-1 STRUT

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.31 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO. D4880	REV. C
MFG. APPR.	JLM	TITLE LEG ASSEMBLY	SHEET 5 OF 5
APPROVED	HS		SCALE
DE APPR.	DS		NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2014-07-07
WMP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34608**

Purchase Order Date 12/13/2016

PO Print Date 12/13/2016

Page Number 3 of 4

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$84.36

6	153804	D4882-1 STRUT	12/13/2016 Yes 12/13/2016	6.00	\$14.06	\$84.36
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						

Line Total: \$84.36

7	153797	D4880-1 STRUT	12/13/2016 Yes 12/13/2016	7.00	\$14.06	\$98.42
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						

Line Total: \$98.42

8	154161	D4884-1 END FITTING	12/13/2016 Yes 12/13/2016	6.00	\$14.06	\$84.36
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						

Note:

12/13/2016



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO30286	Customer: CASH SALE	Dept: NDT YUL	Reference: PO 34608
Descr:	PN: DART AERO	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
			Sequence: 1

Task: UNSCHEDULED

Work Required: CARRY OUT NDT ON THE FOLLOWING ITEMS;

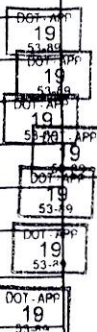
- ① STRUT - ITEM ID D4880-1, WO ID 153891 EA: 6
- ② END FITTING - ITEM ID D4883-5, WO ID 153892 EA: 12
- ③ END FITTING - ITEM ID D4883-3, WO ID 154164 EA: 7
- ④ END FITTING EYE - ITEM ID D4884-1 WO ID 153123 EA: 6
- ⑤ STRUT - ITEM ID D4882-1, WO ID 153804 EA: 6
- ⑥ STRUT - ITEM ID D4880-1, WO ID 153797 EA: 7
- ⑦ END FITTING EYE - ITEM ID D4884-1, WO ID 154161 EA: 6

Action Taken: LIQUID PENETRANT INSPECTION CARRIED OUT JAW ASTM E1417 ON ITEMS LISTED ABOVE

Date: Initial/Stamp:

- ① NO CRACKS FOUND
- ② NO CRACKS FOUND
- ③ NO CRACKS FOUND
- ④ NO CRACKS FOUND
- ⑤ NO CRACKS FOUND
- ⑥ NO CRACKS FOUND
- ⑦ NO CRACKS FOUND

13 DEC 16
13 DEC 16
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13 DEC 16
13 DEC 16
13 DEC 16



Description	Location	P/N	Qty	Batch	S/N Off	S/N On
BLACKLIGHT		T-20990N				
PENETRANT		AR DROX 970	P25E	TPO 19388	APR 02-2018	

DAS
38
9-89
DEC 13 2016

DEC 13 2016

DAS
26
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp:	Date: 13 DEC 2016
Name: GARY SMITH		

SKYM002-1 REV 4 Mar/14